

29

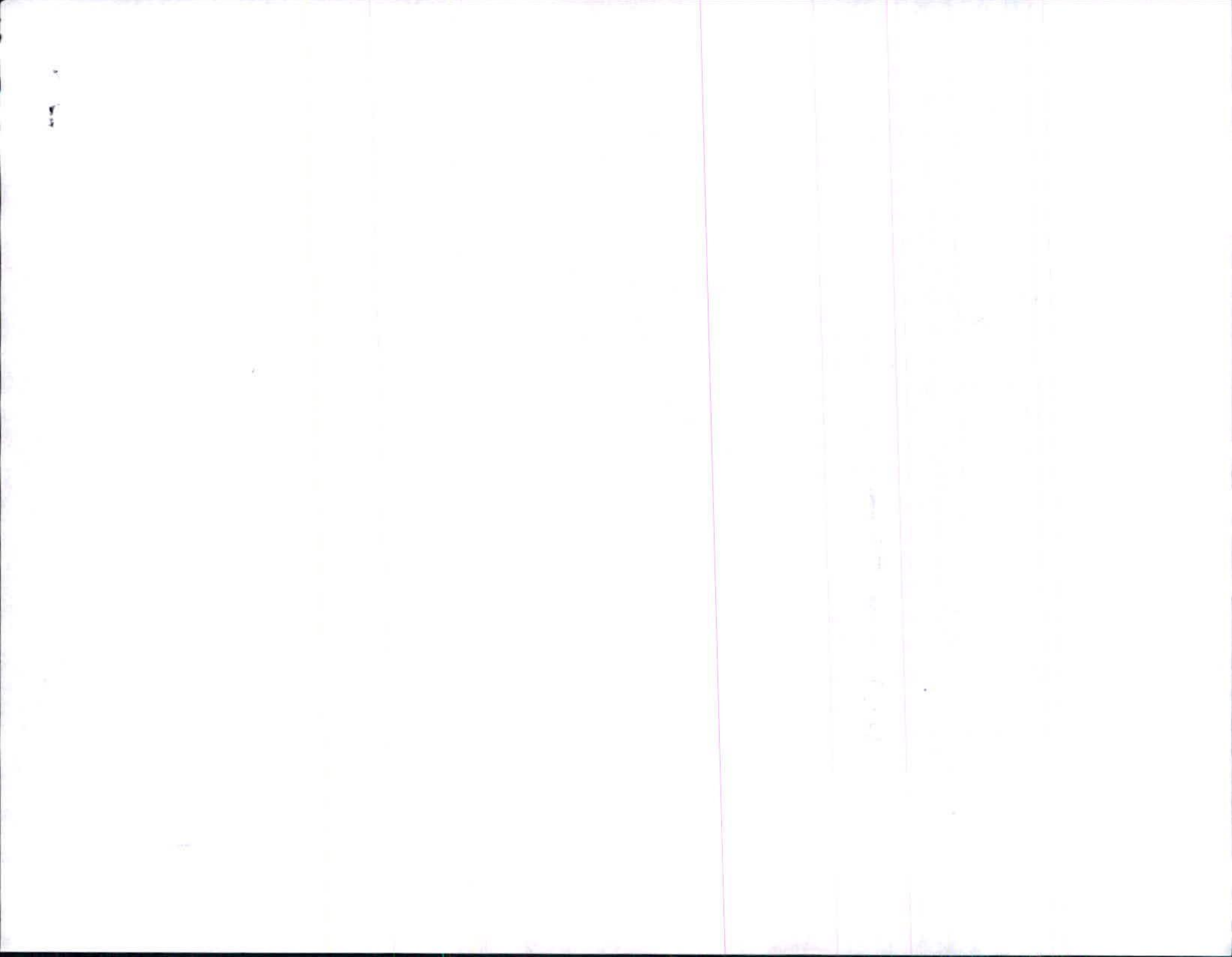
SPLIT

DART AEROSPACE LTD	Work Order:	20957 B
Description: Bearpaw Kit (19" x 16")	Part Number:	K10007
Dwg: D2435 Rev. E1; DSK086-3 Rev. A	Qty:	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required	HA	04.06.01	20																																																
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately)	HA WK 25 HA	04.06.29 04.07.07	10 10																																																
3	GA	Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 19.50" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) Batch: M14864 M15075	HA	04/06/30	20																																																
4	MV	Inspect material for defects or damage prior to machining	HA	04/06/30	20																																																
5	MV	Machine as per Folio D2435 and Dwg D2435 Identify as D2435	HA	04/06/30	20																																																
6	QC2	Inspect parts as they come of the CNC machine	HA	04/06/30	20																																																
7	MV	Deburr	HA	04/06/30	20																																																
8	QC8 & 5	Second inspection	HA	04.07.07	20																																																
9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B20655</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B20957</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B20387</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B20388</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M14544</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M14311</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M14855</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M14478</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M15304</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B20434	8	D2274	Radius Block	B20655	2	D2435	Bearpaw	B20957	4	D2438	Clamp	B20387	8	D2529	Washer	B20388	8	AN4-15A	Bolt	M14544	8	AN4-17A	Bolt	M14311	16	AN960JD416	Washer	M14855	8	MS21042L4	Nut (or -4)	M14478	2	QS200M44S	Clamp	M15304	1	Paperwork package from Step 2			HA	04/07/08	1
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10	QC4	Inspect Kit for 100% Completeness on the W/O	HA	04/07/16	1																																																
11	PK	Identify and pack for shipping as per PPP K10007	HA	04/07/16	1																																																
12	AC	Cost / part 163.86	HA	04/07/28	1																																																
13	DC	Close W/O 148.24 Inspect Level 21	HA	04.08.10	1																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	
E	04.02.17	Blank size changed, tolerance added to Step 3	KJ/JLM	

RELEASED
04.02.20



DART AEROSPACE LTD		Work Order:	20957
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.068x45°	✓		Vern	
B 5.500	+/-0.030	5.503	✓		Vern	
C 0.200	+/-0.030	0.200	✓		Vern	
D R0.250	+/-0.030	R0.250	✓		R-G	
E 0.250	+/-0.010	0.245	✓		Mic	
F 0.625	+/-0.030	0.633	✓		Vern	
G 0.25 x 45°	+/-0.030	0.225x45°	✓		Vern	
H 0.375	+/-0.010	0.367	✓		Vern	
I 19.000	+/-0.030	19.025	✓		M-Tape	
J 0.950	+0.030/-0.010	0.960	✓		Vern	
K Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
L Ø0.930	+/-0.030	Ø0.925	✓		Vern	
M 0.30	+0.030/-0.000	0.320	✓		Vern	
N 0.375	+/-0.030	0.392	✓		Vern	
O 7.375	+/-0.030	7.375	✓		M-Tape	
P 4.250	+/-0.010	4.255	✓		Vern	
Q 2.000	+/-0.030	2.004	✓		Vern	
R 9.000	+/-0.010	9.000	✓		M-Tape	
S 15.750	+/-0.030	15.750	✓		M-Tape	

Measured by: <i>ML</i>	Audited by: <i>BE</i>	Prototype Approval:	N/A
Date: 04/06/30	Date: 04.06.30	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15

